

Work Order ID 60203

Monday, June 28, 2010 3:22:19 PM



Page 1

Item ID: D3283-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/28/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 7/5/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10/6/29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3283

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet
6061 .063

1-Cut as per Dwg D3283
Deburr if necessary

☐ Dwg Rev:

E

☐ Prog Rev:

E

☐ 2-

1810-7-29

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1810-7-29

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Scoloslos

counted
425

25014

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Debur

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

*****ensure rivet fits in #30 (0.128") holes as per dwg *****

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

nl/s

8/10/08/03

21 9A

10/08/04

25

9

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				25	BR	10-8-4	
170  Packaging Packaging	Identify as per dwg & Stock Location: 46 Memo	0.00 0.00				10/8/4	8	(252)	
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				10/08/04	7		

10-8-04
25

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Picklist Print

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Page 1

Work Order ID: 60203

Parent Item: D3283-1

Parent Item Name: Doubler



Start Date: 6/28/2010

Required Date: 7/5/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP ☐ A ☐ 04.09.28 ☐ New issue ☐ KJ/JLM ☐
 IPP Rev:B Now on Waterjet 07-05-28 JLM
 IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	116.6100	0.2361	4.970526			
6061-T6 .063 Sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT21		116.61							
				113608		116.61							

1310-7-09

113608

28

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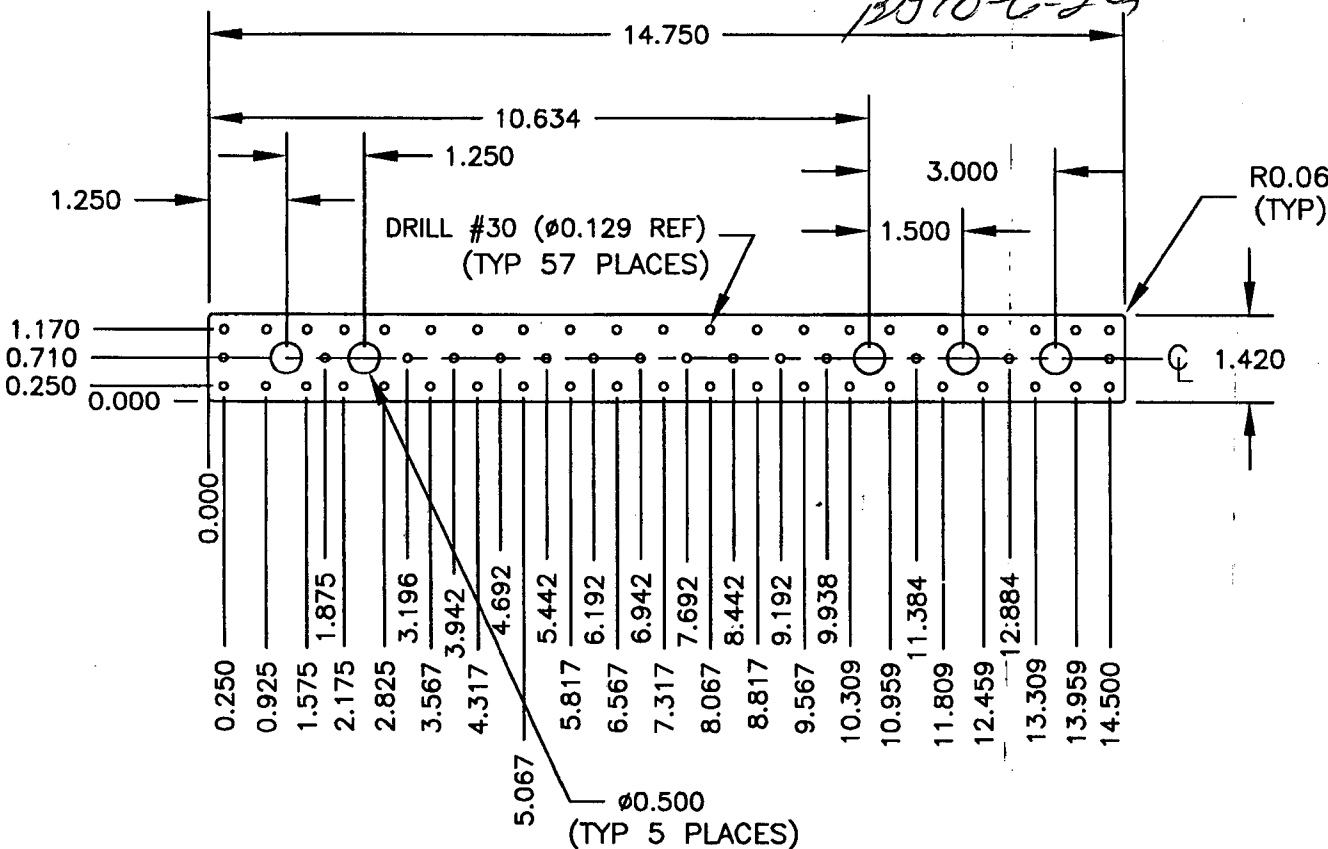
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RELEASED
07-08-99
PER ECN 959

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60203
3810-6-29



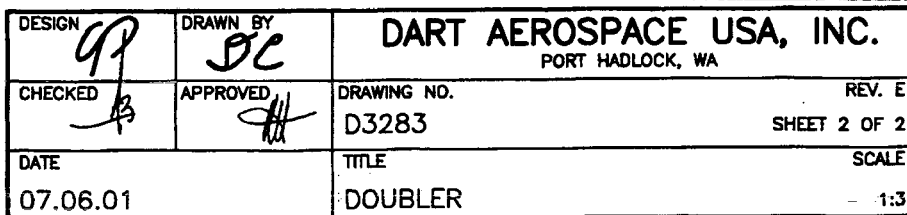
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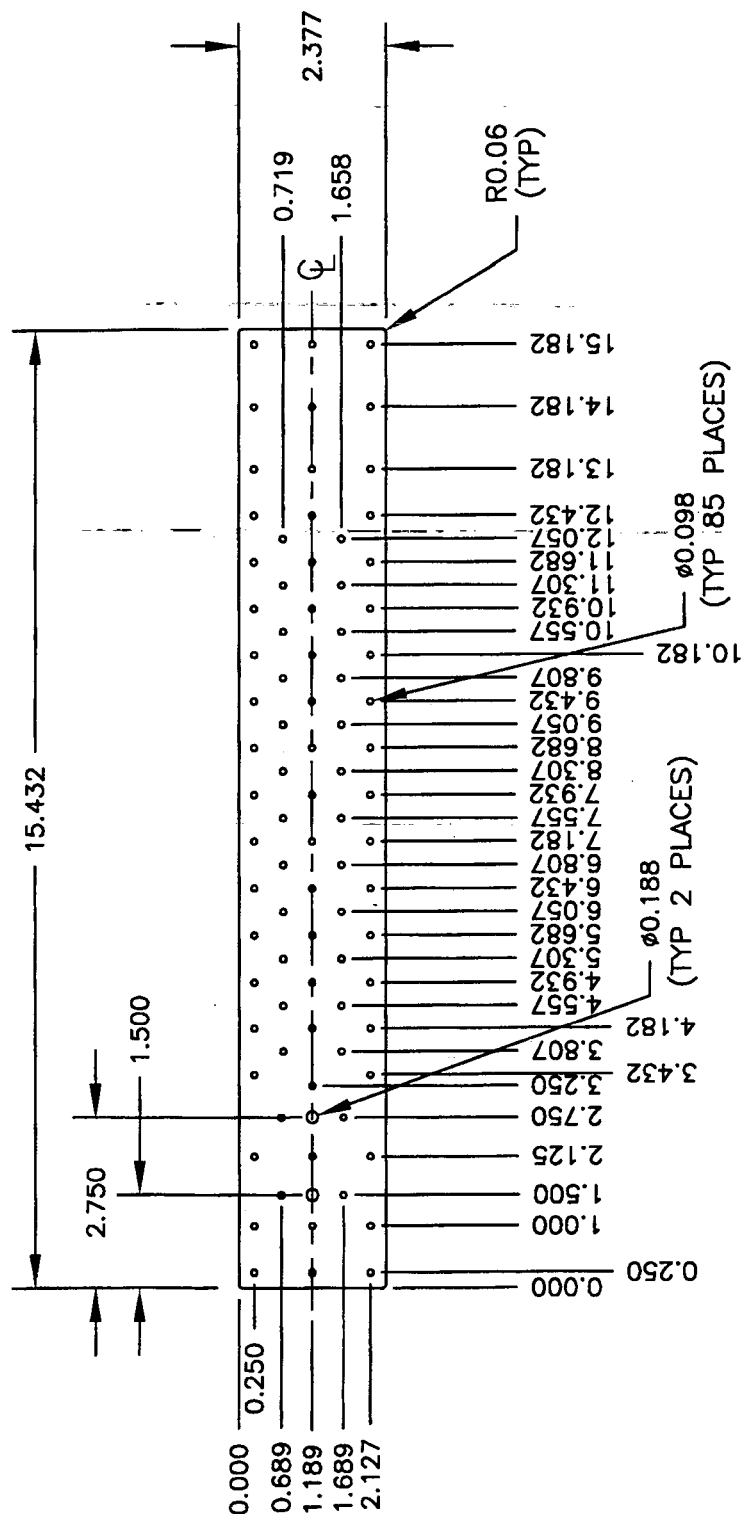
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RELEASED
07-08-27 PM
PER ECN 959

u/o 60203



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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